

Date: Monday, 09/02/2009 4:25:17 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FWD BLADE FOLD ASSEMBLY
<b>Job Number</b> :	45642		
<b>Estimate Number</b> :	13531		
<b>P.O. Number</b> :		<b>Part Number</b> :	PB674300101
<b>This Issue</b> :	09/02/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	B6743001 P.1, 2
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	45641	<b>Drawing Revision</b> :	B1
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	01/04/2009
<b>Written By</b> :		<b>Qty:</b>	1
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	MF 09-03-03		
<b>Comment</b> :	Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300107	Fwd Blade Fold Assembly Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Blade Fold Assembly Weldment

batch: B45050

MF 09-03-11

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: B45041

MF 09-03-11

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: B45043

MF 09-03-11

4.0	PB674300121	PB67-43001-21
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-21

batch: B45038

MF 09-03-11

5.0	PB674300123	PB67-43001-23
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-23

batch: B45035

MF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45642

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Longitudinal Support Assembly

batch: B45028

MF 09-03-11

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Long T-Handle Assembly

batch: B45026

MF 09-03-11

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever Arm

batch: B43093

MF 09-03-11

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: B41373

MF 09-03-11

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: B410062

MF 09-03-11

11.0

D3451041

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: B45307

MF 09-03-11

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: B45310

MF 09-03-11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45642

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Spacer

batch: B45016

MF 09-03-11

14.0

D34477

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

batch: B43926

MF 09-03-11

15.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Swing Arm

batch: B41352

MF 09-03-11

16.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Belt Assembly

batch: B39966

MF 09-03-11

17.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: m/09350

MF 09-03-11

18.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

batch: m/18431

MF 09-03-11

19.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SCREW

batch: m/18057

MF 09-03-11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45642

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: m 110399

MF 09-03-11

21.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch: m 109282

MF 09-03-11

22.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: m 108183

MF 09-03-11

23.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m 108986

MF 09-03-11

24.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m 108986

or MS51859-7 (see engineering) batch: m 106421 x4

MF 09-03-11

25.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: m 109060

MF 09-03-11

26.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m 11117

MF 09-03-11

W/O:		WORK ORDER CHANGES					
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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch: m108057

MF 09-03-11

28.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m18057

MF 09-03-11

29.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m18057

MF 09-03-11

30.0

AN960JD6

Washer



Comment: Qty.: 6 2.0000 Each(s)/Unit Total : 6 2.0000 Each(s)

Washer

batch: m6085

MF 09-03-11

31.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m107178

MF 09-03-11

32.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: m110865

MF 09-03-11

33.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:                     

or AN415A (see engineering) batch: m110399

09.03.10

MF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: M105558

MF 09-03-11

35.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: \_\_\_\_\_

or AN6C16A (see engineering) batch: M105831

MF 09-03-11

36.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: M18180

MF 09-03-11

37.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIVET

batch: M109119

MF 09-03-11

38.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cherry rivet

batch: M104214

MF 09-03-11

39.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PIN, QUICK RELEASE

batch: M108986

or MS17984C410 (see engineering) batch: M109739

MF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45642

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

MF 09-03-11

41.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

8" LANYARD

batch: m108973

MF 09-03-11

42.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

LANYARDS

batch: m108973

MF 09-03-11

43.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPRING SLOTTED PIN

batch: m111088

MF 09-03-11

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: m109687

FL 09/03/11

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-11

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 4 5655

09/13/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/12 *AF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*  
09-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# 45642

RELEASED

